Date: Monday, 8/13/2007 1:13:31 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 EXTRUSION BENDING
Job Number	: 33880		
Estimate Number	: 10311		
P.O. Number	: N/A	Part Number	: D2620
This Issue	: 8/13/2007 S.O. No. : N/A	Drawing Number	: D2620 REV B
Prsht Rev.	: NC	Product Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 33879	Material	: N/A
Written By	: CM/07-08.13	Due Date	: 8/20/2007 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D26001160	Extrusion Round 3" 206

Comment: Qty.: 1.0000 Each(s)/Unit   Total : 20.0000 Each(s)
Extrusion Round 3" 206
Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	30249

EL 7-8-27

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
1-Bend extrusion as per Dwg D2620 usingCNC Bending Machine program 206.A
and Folio Ft008
2- Cut Fwd end of tube as per Dwg D2620

EL/M 7-8-27

3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

BE 7-09-06

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: LG

BE 7-09-06

5.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/09/06

Job Completion

U 8-09-06

Form: rprocess

SPECIFICATION CONTROL DRAWING
206 SKIDTUBE BENDING

(REF)
35.0

125.0

160.0

FLAT LENGTH OF D2600-1 EXTRUSION

BEND TANGENT

55°
(REF)

R30.0

5.0

17.1

125.0
(REF)

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
   NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
   DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
   TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
   TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
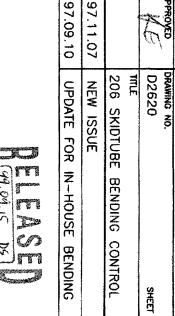
NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
99.04.15 DS

DART AEROSPACE USA, INC.
FAIRCHILD INTERNATIONAL AIRPORT, WA

DESIGN
DRAWN BY RF
CHECKED
APPROVED KE

	DATE	
B	99.09.10	
A	97.11.07	NEW ISSUE
	97.09.10	UPDATE FOR IN-HOUSE BENDING

DRAWING NO. D2620
REV. B
TITLE 206 SKIDTUBE BENDING CONTROL
SHEET 1 OF 1
SCALE 1:20